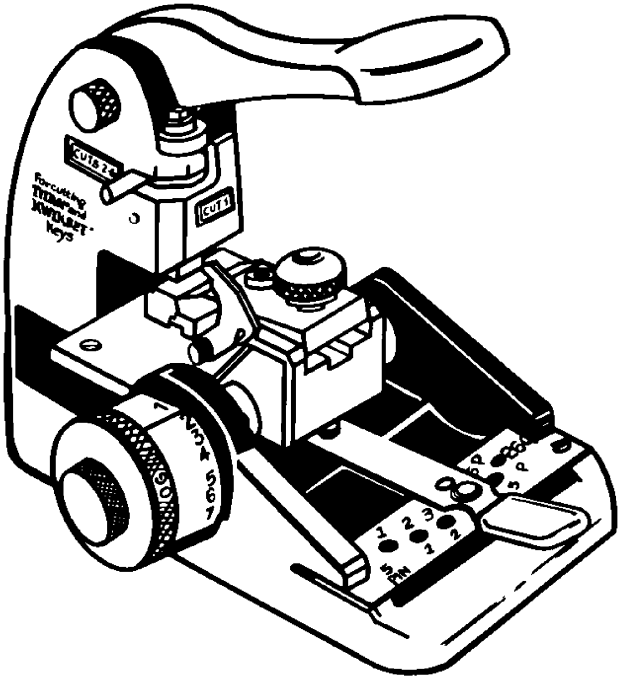
For cutting Titan® and Kwikset® keys by code

INSTRUCTION MANUAL

IMPORTANT! Read these instructions before you use your new Exacta Machine



ILCO UNICAN®

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Code No. 125321

This manual applies specifically to the MKIII model Exacta. It identifies the MKIII model and assures you will receive correct replacement parts, if or when they are required. Retain this manual in a safe place for future reference. If ownership of this machine is transferred, this service manual should accompany the machine.

When seeking service information about this machine, refer to the model no. (Exacta MKIII), the machine serial number (located on the bottom of the unit) and the part number desired (See pages 7-8). Note that Exacta MKI and MKII parts and accessories **are not** interchangeable with the Exacta MKIII.

CONTENTS

Warranty 2
Introduction to the Exacta 3
Operating Parts (Illustrated).....4
The Cutting Operation - Theory of Operation - Components 5
The Cutting Operation - Operating the Exacta 6
Exploded View 7

ONE YEAR LIMITED WARRANTY

ILCO UNICAN warrants to the original buyer of any new model Exacta machine that it will repair or replace, at its option, any part of any machine which proves, to the reasonable satisfaction of ILCO UNICAN, to have defects arising from the faulty manufacture of the machine or from defective material or components, during a period of (1) year from the date of shipment of the machine by ILCO UNICAN, provided that the machine is returned by prepaid transport to ILCO UNICAN or to its authorized representative before the expiry of the warranty period together with a detailed description of the alleged defect(s). ILCO UNICAN may, at its discretion, elect to refund the purchase price allocable to the part affected, or to issue a credit if the price therefore remains unpaid.

ILCO UNICAN sells precision-made machines. The buyer assumes all risks, and ILCO UNICAN shall not be liable for any reason, if the machine has been subjected to improper installation, improper use, improper or inadequate maintenance, negligence, if any unauthorized modification or alteration is made to the machine, or in case of accident. For greater certainty, any machine not operated in accordance with ILCO UNICAN's printed instructions or operated beyond its rated capacity shall not be covered by this or any other warranty.

Any and all warranties made by ILCO UNICAN on any machine, product, or component thereof shall be effective only if and for so long as the buyer complies with all payment obligations pursuant to the buyer's accepted and acknowledged order. Failure to meet such payment obligations shall void all warranties and not extend the period of time for which such machine, product or component thereof is warranted irrespective of whether or not payment is eventually made.

These warranties are in lieu of and not in addition to any other warranty of condition, expressed or implied, including without limitation merchantability, fitness for a particular purpose or latent defects. The buyer releases ILCO UNICAN from any liability for any reason other than a breach of its warranties hereunder.

The liability of ILCO UNICAN shall in no case, including negligence, exceed the purchase price of the defective machine, nor shall ILCO UNICAN be liable for any personal injuries, property damage or consequential damages.

Use only genuine ILCO UNICAN replacement parts on this machine!

Registration and Serial number is:_____

INTRODUCTION

Congratulations!
You've purchased a superior key cutting machine.

The Exacta MKIII is a portable, hand operated key machine, specifically designed and engineered to cut TITAN® and Kwikset® keys by code, without electrical power. It will cut these type keys by number, according to the manufacturer's depth and spacing specifications. A pattern key is not needed since this machine is **not** a key duplicator.

The Exacta MKIII is the only machine of its kind available that can produce the unique 90° cut found in the first spacing position of a TITAN key as well as the "standard" type cuts used in positions 2-6 and on non-Titan Kwikset keys. This is accomplished thanks to a unique dual-position punch which allows for instant changeover from one cut type to the other.

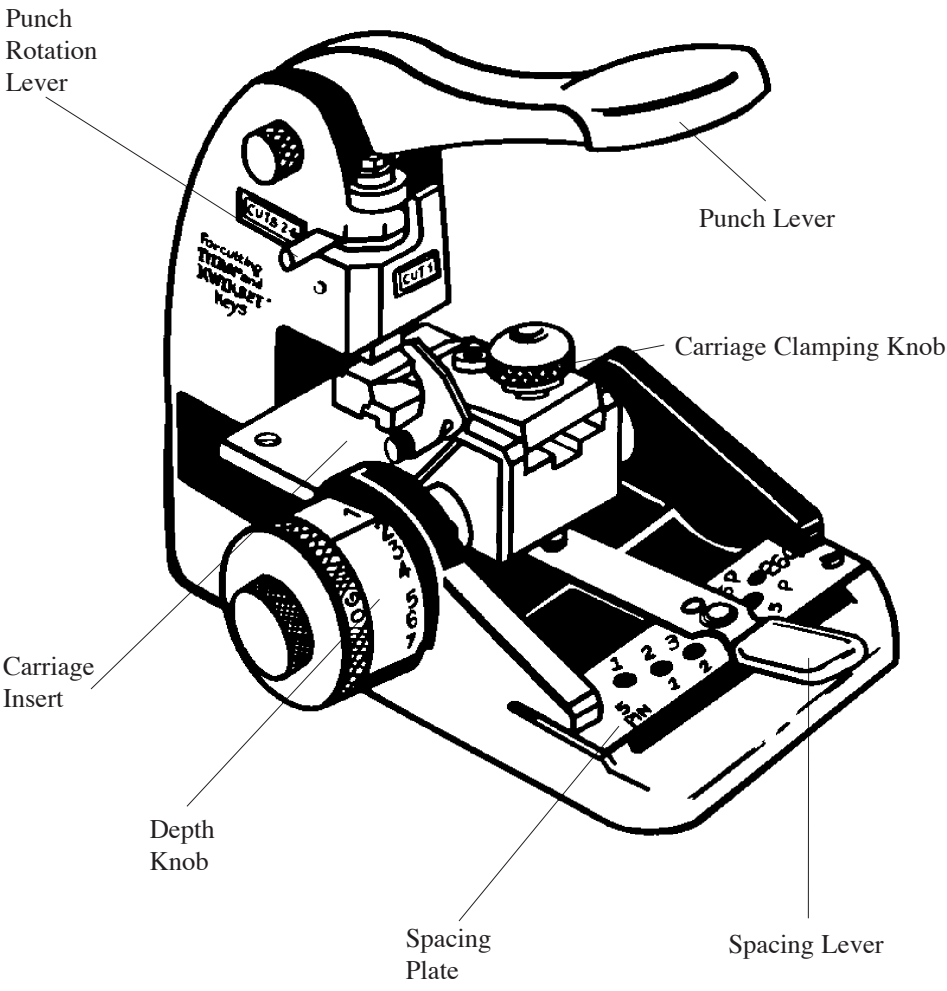
The Exacta MKIII is easy-to-use and maintain. If proper care is taken, your machine will give years of trouble-free service and will be a long-lasting investment.

The only maintenance necessary is to keep the Exacta MKIII and its parts free of dust and brass chips by regularly cleaning with a soft brush. Lubrication is normally not necessary.

UNPACKING INSTRUCTIONS

Your new Exacta MKIII code cutting machine has been shipped to you in a sturdy carton designed to protect it from damage. The unit has been fully tested prior to shipment, and as packed, is ready for use. Please familiarize yourself with the operating parts of the unit as shown on page 4 before proceeding to the Operating Instructions.

OPERATING PARTS



THEORY OF OPERATION - COMPONENTS

There are basically two critical dimensions involved in cutting a key by code — spacing of the cuts and depth of the cuts.. Spacing refers to **where** the cuts are placed along the blade of the key and depth refers to how deeply the notch (cut) is made into the blade of the key.

Five basic components on the Exacta MKIII control these important dimensions:

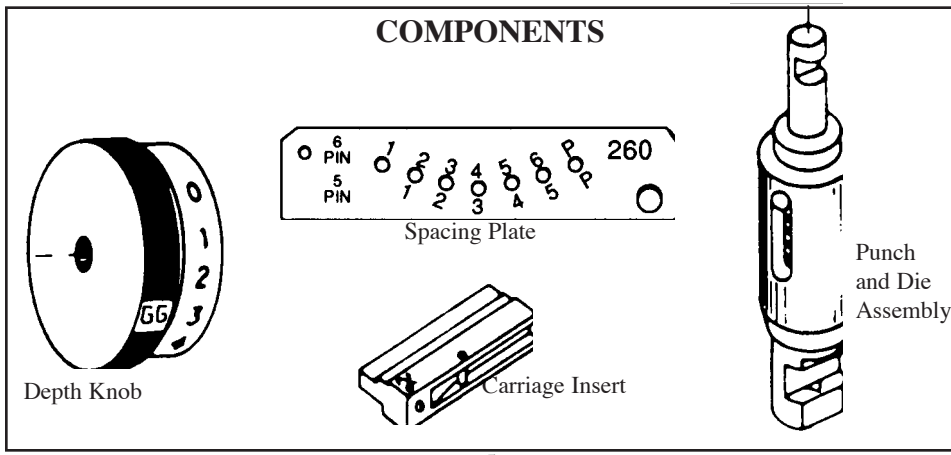
Spacing Plate: The spacing plate controls the location of the cuts on the blade of the key. The part no. for the MKIII plate is P11-260. The top surface of the plate has holes drilled through it and two sets of numerals stamped on it. The set stamped above the holes is identified "6 pin", the set below "5 pin". Utilize the "6 pin" numbers when cuttingTitan® keys and the "5 pin" numbers when cutting standard Kwikset® keys.

Depth Knob: The depth knob controls the actual depth of each cut. It is stamped with numbers 1-8. The higher the number selected, the deeper the cut that will be produced on the key. The part no. is P10-GG.

Carriage insert: Provides a stable resting surface for the key blank being held in the carriage. The part no. is P12-21.

Punch and Die assembly: Produces the actual notch (cut) in the key blank. The MKIII punch and die operates in one of two positions; "cut 1" position is for producing the cut closest to the head of a TITAN key, "cuts 2-6" position is for producing the remaining cuts on a TITAN key as well as all cuts found on a standard Kwikset key. The part no. is P13-T.

Shoulder Guide: Located on the left side of the carriage. After the key blank has been positioned on the insert, the shoulder guide is rotated down to form a stop. The key blank is then pushed to the right until its shoulder contacts the shoulder guide, at which point the carriage knob is tightened to secure the key blank in position. The should guide MUST be returned to the "UP" position before proceeding further with the key cutting procedure to prevent damaging it.



THE CUTTING OPERATION

OPERATING THE EXACTA

The following describes how to operate the Exacta MKIII to produce a key cut to a specific key bitting number you have chosen. For the purpose of this example we will assume that the key to be cut is a TITAN key, to be bitted 3 - 4 - 4 - 5 - 4 - 2, with the "3" being the cut closest to the head of the key and the "2" being the cut nearest the tip.

1. Turn punch rotation lever to the "cut 1" position (required for first cut on TITAN keys only; cuts 2-6 on TITAN keys and **all cuts on Kwikset keys are made with the punch rotation lever in the "cuts 2-6" position).**

2. **Lift the spacing lever and position it so that the attached pin enters the hole designated "P" on the** right side of the spacing plate. (Remember to utilize the set of numbers above the indexing holes on the spacing pate, designated "6 pin", when cutting TITAN keys.)

3. Rotate the depth knob so that its lowest number (#1) is next to the index mark on the machine base.

4. Position the key blank on the carriage insert, lower the shoulder guide, and tighten the carriage clamping knob to secure the key, after first insuring that the shoulder of the key blank is in contact with the edge of the shoulder guide. Return the shoulder guide to the "up" position once the key blank has been clamped in position (very important).

5. Begin the actual cutting procedure by lifting the spacing lever and positioning it to enter the hole of the spacing plate marked 1. (Remember, "6-pin" for TITAN keys, "5-pin" for Kwikset keys.) This is the first spacing position.

6. Refer to the bitting number specified for the key to be cut, in this example 3-4-4-5-4-2.

7. Rotate the depth knob so that 3 appears next to the index mark on the machine base. The 3 represents the first number of the above bitting example. Depress the punch lever and a no. 3 cut will be produced in the first spacing position. Rotate the depth knob to the "1" position and move the punch rotation lever to the "cuts 2 - 6" position before producing the remaining cuts on the key.

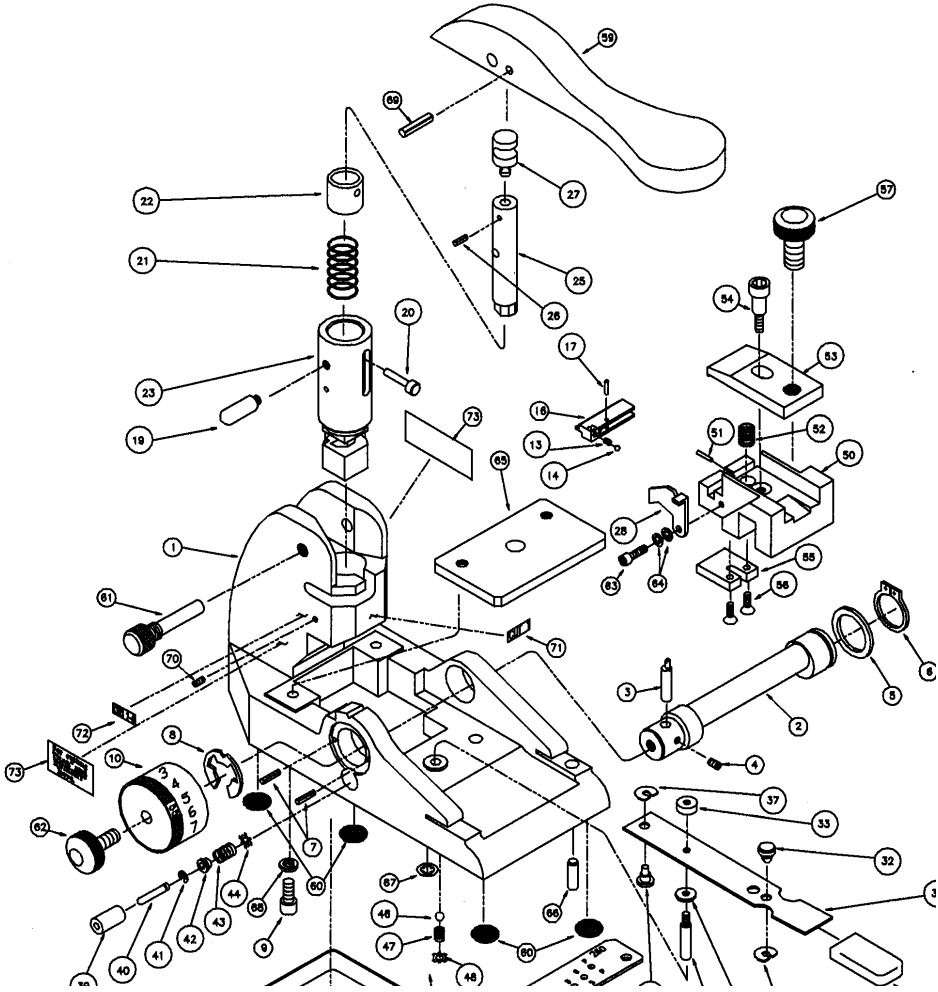
8. Lift the spacing lever and move it so it's pin drops into the hole in the spacing plate marked 2. The key has now shifted to the second spacing position.

9. Rotate the depth knob so that 4 appears next to the index mark on the machine base. Depress the punch lever and a no. 4 cut will be produced in he second spacing position;

10. Continue making the remaining four cuts, 4-5-4-2, in the same manner.

11. Loosen the carriage clamping knob to remove the completed key.

EXPLODED VIEW



EXPLODED VIEW

Refer to page 7 for illustration.

Part No.	Description
MKIII-1	MKIII Base
MKIII-2	Eccentric (MKII)
MKIII-3	Eccentric Adjustment Screw
MKIII-4	Set Screw
MKIII-5	Washer
MKIII-6	Retaining Ring
MKIII-7	Spring Pin
MKIII-8	Retaining Ring
MKIII-9	Socket Head Cap Screw
MKIII-10	Depth Knob (GG)
MKIII-11	Spacing Plate (260)
MKIII-12	P12-21 Insert Assembly
MKIII-13	Compression Spring
MKIII-14	Steel Ball
MKIII-15	P12-21 Insert Sub-Assembly
MKIII-16	Insert Body (21)
MKIII-17	Roll Pin
MKIII-18	MKIII Punch & Die Assy.
MKIII-19	Rotation Lever
MKIII-20*	Guide Pin
MKIII-21*	Punch Spring
MKIII-22*	Guide Bushing
MKIII-23*	Die-Sleeve Assembly
MKIII-24*	MKIII Punch Subassembly
MKIII-25*	MKIII Punch Body
MKIII-26*	Spring Pin
MKIII-27*	MKIII Punch Top
MKIII-28	MKII Left Side Shoulder Guide
MKIII-29	Spacing Lever Assembly
MKIII-30	Spacing Lever
MKIII-31	Flat End Cap (Black)
MKIII-32	Dial Pin
MKIII-33	Trunnion Nut
MKIII-34	Trunnion Washer
MKIII-35	Trunnion
MKIII-36	Carriage Pin
MKIII-37	Retaining Ring

Part No.	Description
MKIII-38	MKI/MKII Depth Knob Detent Assembly
MKIII-39	Plunger Housing
MKIII-40	Plunger
MKIII-41	Snap Ring
MKIII-42	Spring Retainer
MKIII-43	Spring
MKIII-44	Retaining Ring
MKIII-45	Spacing Plate Detent Assy.
MKIII-46	Steel Ball
MKIII-47	Spring
MKIII-48	Retaining Ring
MKIII-49	MKII Carriage Assembly
MKIII-50	MKII Carriage
MKIII-51	Roll Pin
MKIII-52	Clamp Spring
MKIII-53	Clamp
MKIII-54	Shoulder Socket Head Cap Screw
MKIII-55	Carriage Plate
MKIII-56	Flat Head Screw
MKIII-57	Clamp Screw
MKIII-58	Plastic Box
MKIII-59	Lever (Black)
MKIII-60	Felt Pad
MKIII-61	Lever Screw
MKIII-62	Depth Knob Screw
MKIII-63	Socket Head Cap Screw
MKIII-64	Belleville Washer
MKIII-65	Guide Plate
MKIII-66	Dowel Pin
MKIII-67	Retainer
MKIII-68	#10 Lock Washer
MKIII-69	Spring Pin
MKIII-70	Ball Plunger
MKIII-71	Cut 1 Label
MKIII-72	Cut 2-6 Label
MKIII-73	MKIII Logo Label

* Parts MKIII20 - 27 are not available as separate items. Order MKIII-18 Punch and Die Assembly.